

05/21
Work Order ID 162370

Tuesday, June 06, 2017 4:57:31 PM

162370

Page 1

Item ID: 647.4115

Revision ID:

Item Name: Shim

Start Date: 6/9/2017 Start Qty: 10.00

Required Date: 6/22/2017 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: DAS Date: JUN 12 2017 Tooling: _____ Date: _____

QC: 21 Date: _____ SPC (Y/N): _____ Date: _____

9-89

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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647.4100	n/c
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110

0.16

110

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: AK

Prog Rev: AK

2-Deburr if necessary

0.11

(10)

SC 17/06/25

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.10

(10)

SC 17/06/25
P 17-06-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER :							

Work Order ID 162370

Tuesday, June 06, 2017 4:57:31 PM

162370

Page 2

Item ID: 647.4115 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Shim
Start Date: 6/9/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 6/22/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.20				<u>10</u>			DAS 38 9-88 JUN 26 2017
140 *140* Outsource4 Outsource process - Anodize	Outsource process-Anodize per QSI017 4.1.10.1 Memo Issue P/O to ATG : <u>34017</u> 1- Black Anodize as per Dwg 647.4100 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Comformity is required	0.00 1,800.00				<u>10</u>			<u>17/07/12</u>
150 *150* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo	0.00 0.20				<u>10x</u>			<u>SP17-8-9.</u>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Page 3

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo <i>1.8 mils thickness primer</i>	0.00 0.20				<i>10</i>			DAS 38 9-89 AUG 10 2017
190 *190* Packaging Packaging	Identify as per dwg & Stock Location <i>CK12</i> Memo ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***	0.00 0.10				<i>10</i>			UW 8/14/17 DAS 6 9-89 AUG 14 2017
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 1.00							DAS 21 9-89 AUG 16 2017

AUG 14 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Monday, June 05, 2017 4:53:42 PM

Page 18

Work Order ID: 162370

162370

Parent Item: 647.4115

647 4115

Parent Item Name: Shim

Start Date: 6/9/2017

Required Date: 6/22/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 12.10.26 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.090

Purchased

No

110

sf

45.7700

0.022

0.231579

M2024T3S 090

**

SC 17/06/25

2024-T3 .090 sheet

Location

Loc Qty

Loc Code

MAT021

45.77

123287

13.07

m130387

32.7

0.25

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NL 04510

SHEET 1 OF 1

DWG NO. 647.4100

REV: N/C

PREPARED
BY:

J. BECKER

DATE: 04/24/14

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: SHEETMETAL

APPROVED BY:

ENGR:

MFG

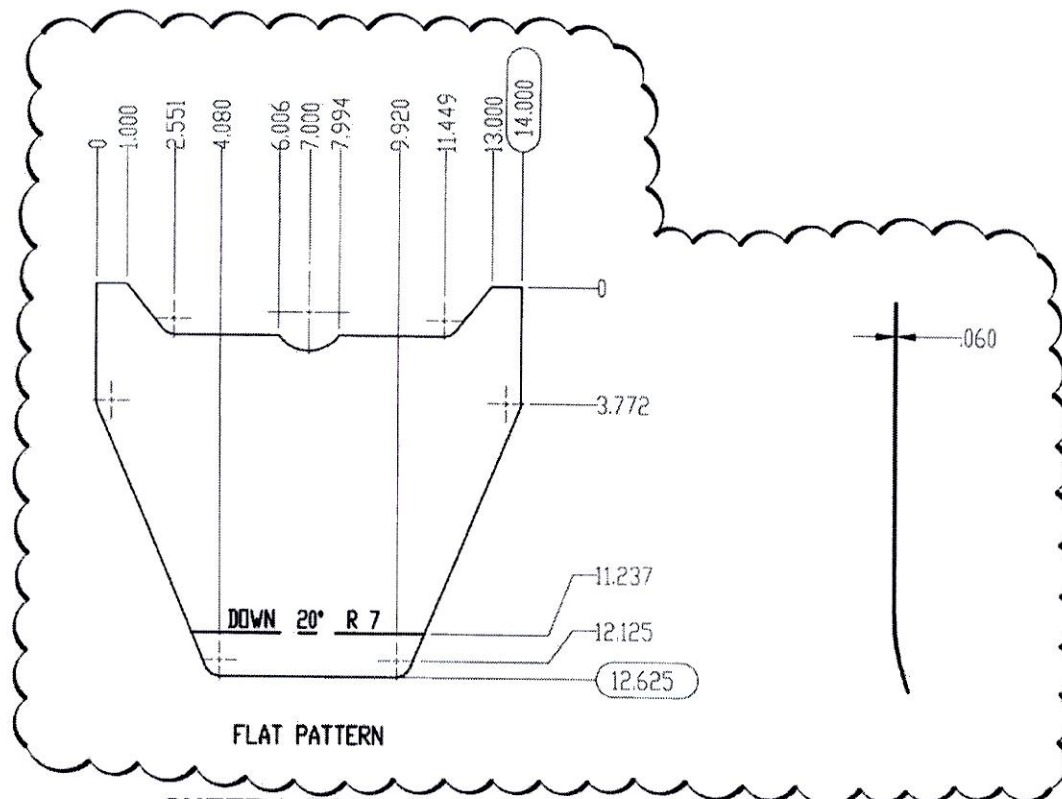
QC

EFF:

NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: MODIFIED DOUBLER.



SHEET 1, ZONE C2 IS:

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 162370 MCS
1706-12

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BOM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED
☐ YES ☒ NO

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 02866

SHEET 1 OF 1

DWG NO. 647.4100

REV: N/C

PREPARED
BY

R. ROSANO

DATE: 05/05/10

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: SHEET METAL

APPROVED BY:

ENGR

MFG

QC

EFF:

CURRENT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: CHANGED PRETREATMENT CALLOUT

SHEET 1, ZONE A1 IS:

NOTES: UNLESS OTHERWISE SPECIFIED

1. MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4

2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE II,
CLASS 2, COLOR BLACK;
PRETREAT PR-148 ADHESION PROMOTER
PRIME IAW MIL-P-23377J TYPE I CLASS N

IS

3. DEBURR AND BREAK ALL SHARP EDGES

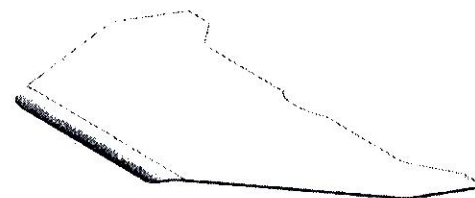
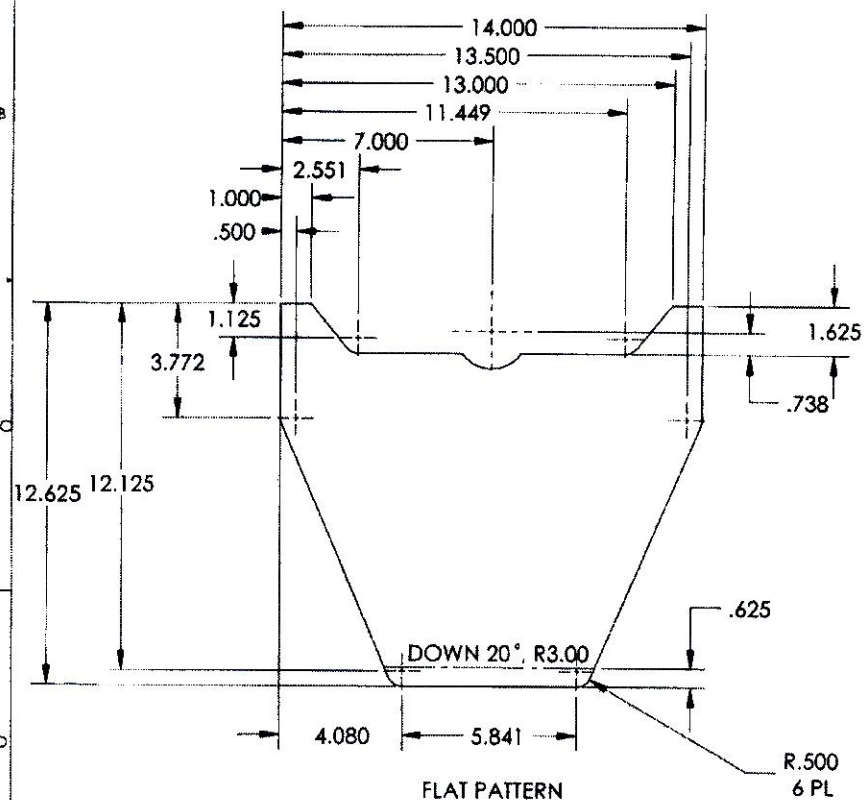
4. IDENTIFY IAW MPP-120

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED ☐ YES ☒ NO

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NOTES: UNLESS OTHERWISE SPECIFIED

1. MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE II, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120



647.4110

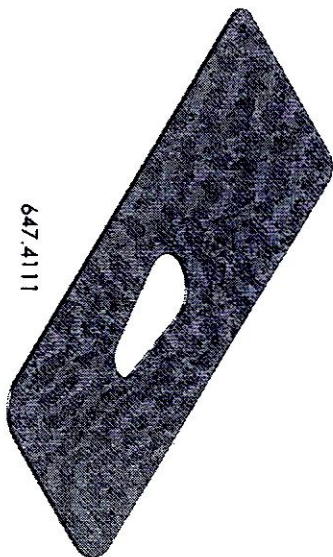
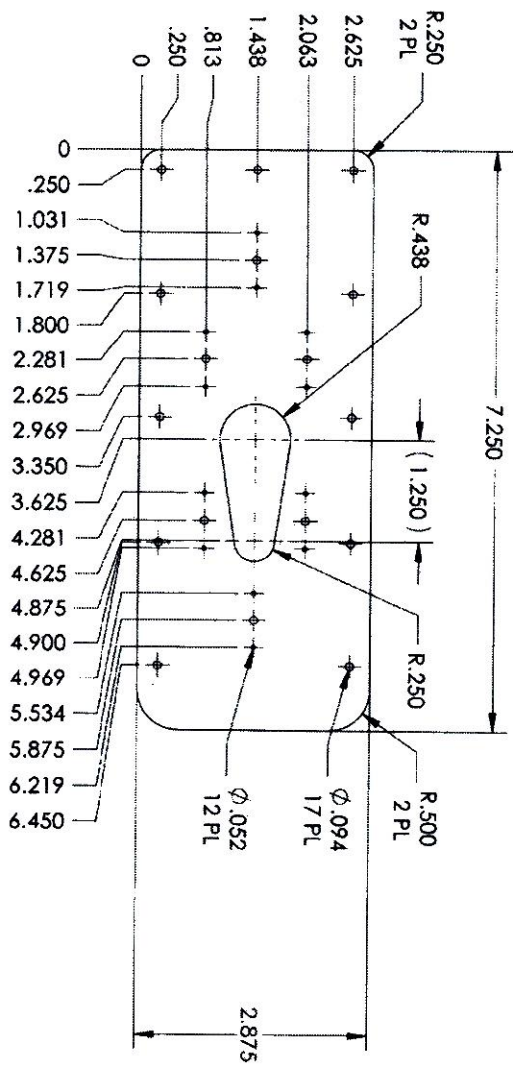
UNINCORPORATED ECN(s)

028610, 04510

QTY	FIND #	PART #	DESCRIPTION	MATL	SPEC.
		647.4116	SHIM	△	△
		647.4115	SHIM	△	△
		647.4114	SHIM	△	△
		647.4113	CLIP	△	△
		647.4112	CLIP	△	△
		647.4111	DOUBLER	△	△
		647.4110	DOUBLER	△	△

ORIGINAL DATE 10/24/88	DESIGNED BY B. POSANO	REVIEWED BY D. BARBER	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300
DRAWING APPROVAL BY: [Signature]			SHEETMETAL
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES DIMENSIONS ARE PLACE DECIMALS 2-3 TOLERANCES: HOLE ± .015			REV 1 DATE 07/28/88 SCALE NONE

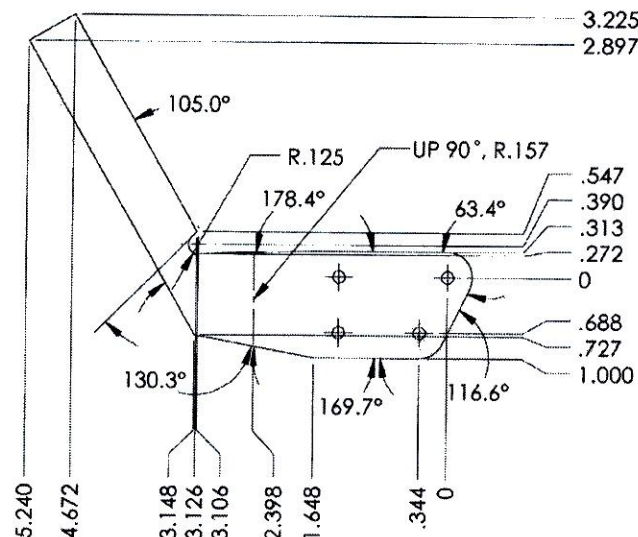
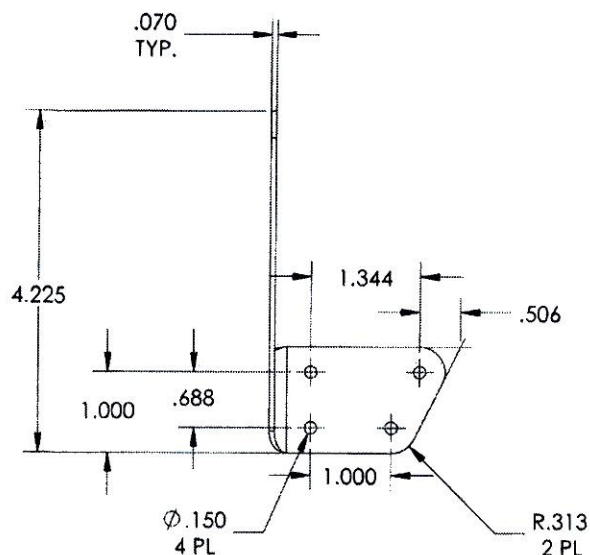
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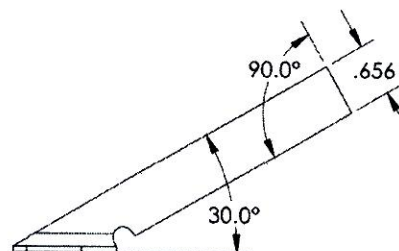
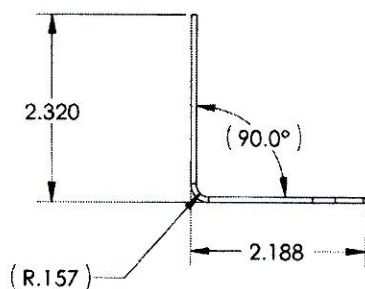
APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760) 724-5300		SHEETMETAL	
PROJECT: 1000 DRAWING: 1000 DATE: 10/1/00 SCALE: 1:1	SHEET: 2 OF 8	647.4100	N/C

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



FLAT PATTERN



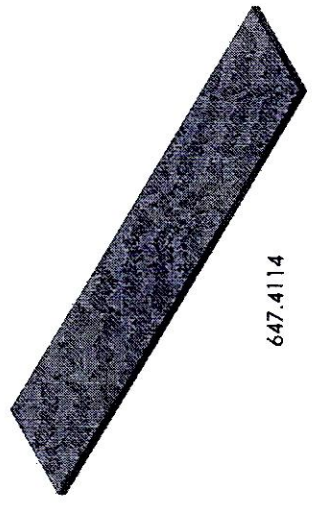
647.4113 SHOWN
647.4112 OPPOSITE

ORIGINAL DATE: 08/24/16 DRAWN BY: P. ROSANO CHECKED BY: D. BARBER APPROVED BY: P. ROSANO DATE: 08/24/16	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1. PLACES DECIMALS 1.01 2. SPACES 1/8" - 1.00 3. ANGLES 1/2°	SHEETMETAL SIZE: 8 D7M16 SCALE: NONE PART NO: 647.4100 REV: N/C SHEET 3 OF 6

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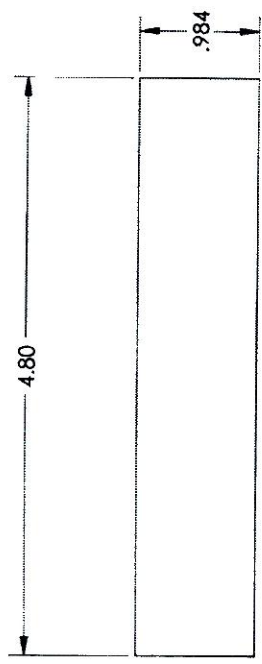
1 2 3 4 5 6 7 8

REV.	DESCRIPTION	DATE	APPROVED

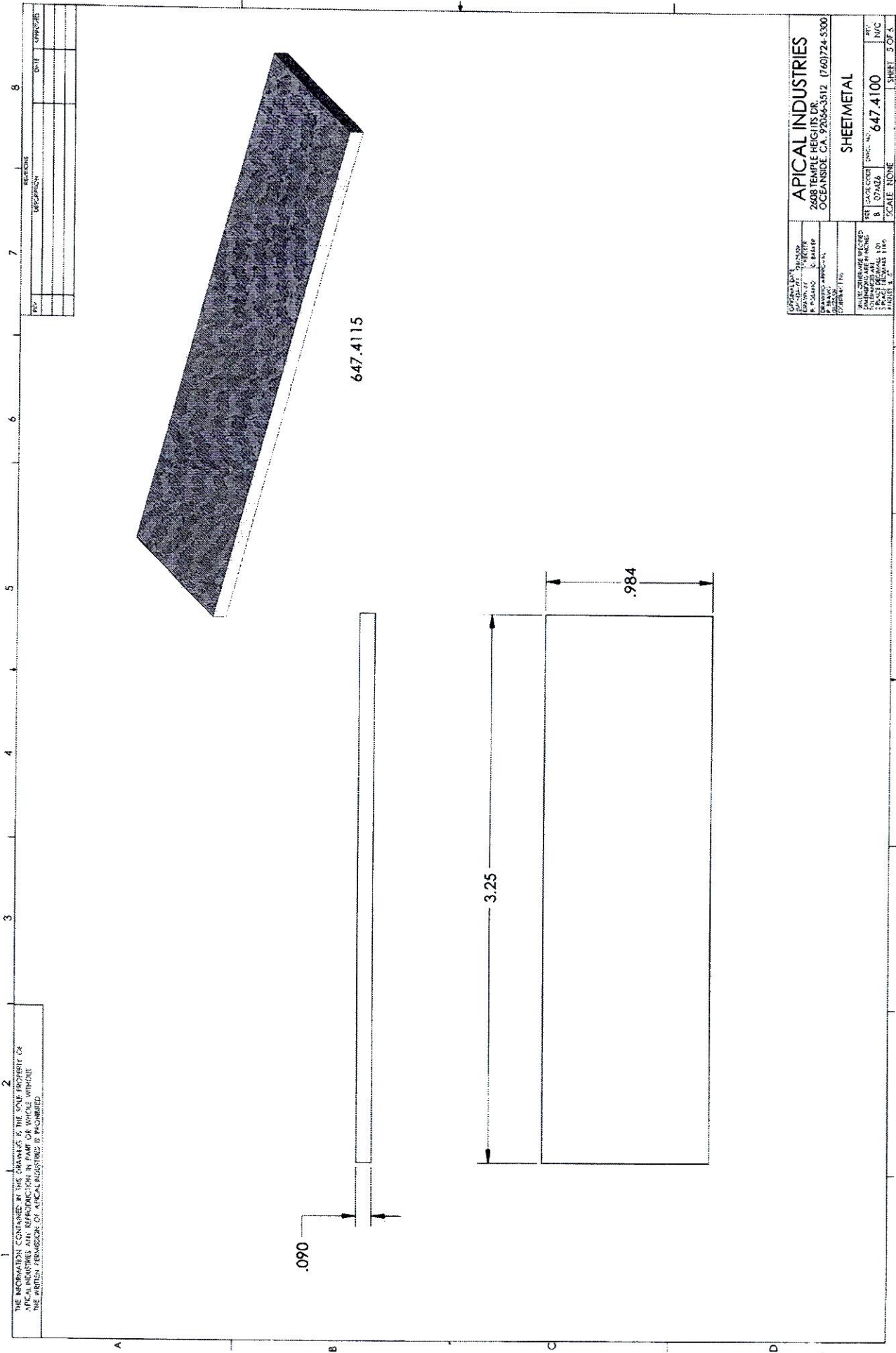


647.4114

.063



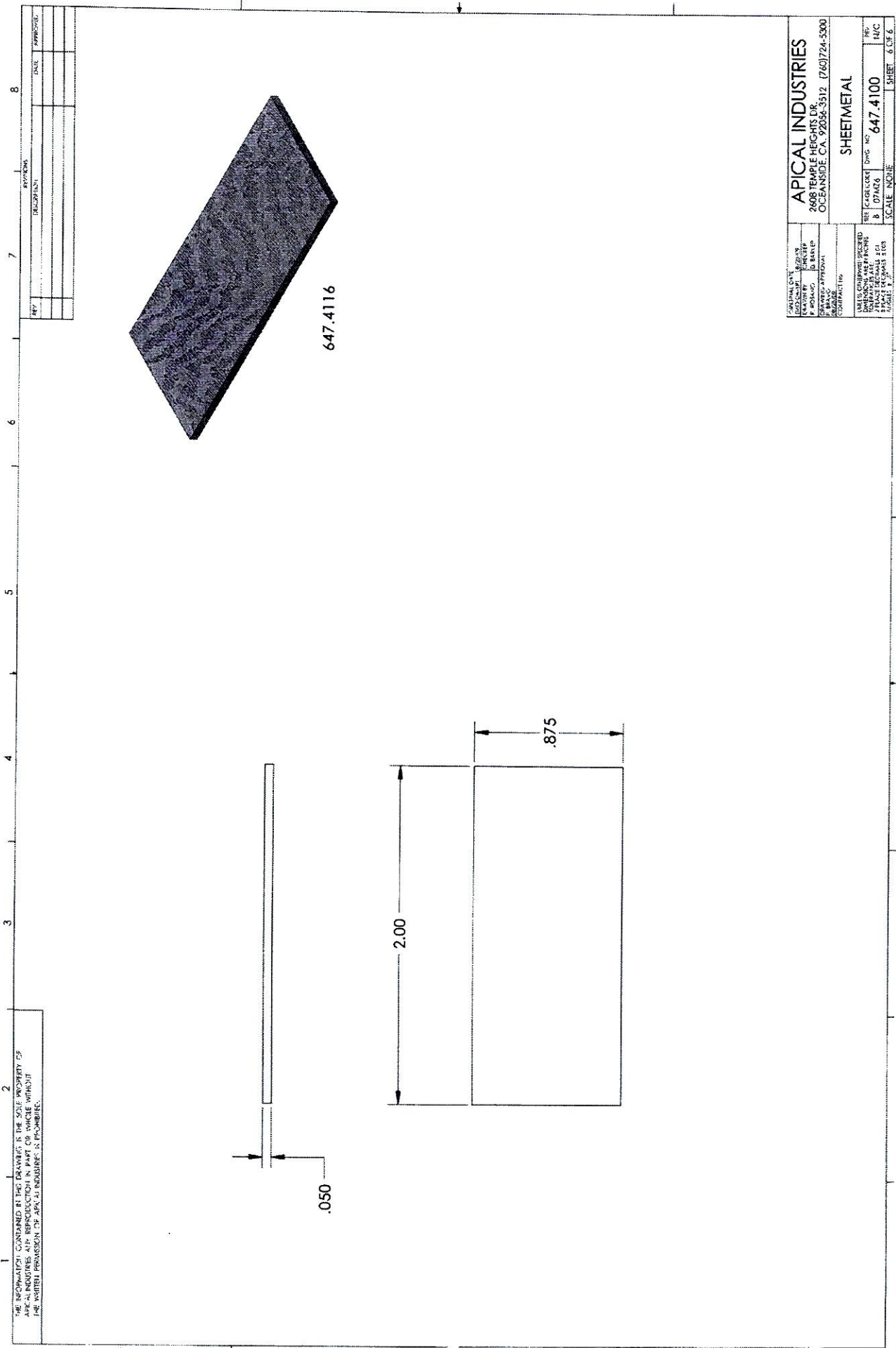
APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		SHEETMETAL	
COMPANY: APICAL INDUSTRIES DRAWN BY: J. B. JONES CHECKED BY: J. B. JONES DATE: 10/1/88	SCALE: NONE	JOB NO: 647.4100	REV: N/C
SHEETMETAL UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES DIMENSIONS ARE WALL THICKNESS DIMENSIONS ARE WALL THICKNESS DIMENSIONS ARE WALL THICKNESS		SHEET 4 OF 4	



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REV	DESCRIPTION	DATE	APPROVED

APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300	
CUSTOMER: APICAL INDUSTRIES PART: 647.4115 QUANTITY: 100 DATE: 1/1/00	SHEETMETAL SCALE: 1:1 SHEET: 3 OF 3



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REV	DESCRIPTION	DATE	APPROVED

APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92036-3512 (760) 724-3300	
SHEETMETAL	
APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92036-3512 (760) 724-3300 FAX (760) 724-3301 WWW.APICALINDUSTRIES.COM	SHEET 6 OF 6 DWG NO. 647.4100 REV. 1 DATE 11/11/03 SCALE NOTE



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37017**

Purchase Order Date 7/12/2017

PO Print Date 7/19/2017

Page Number 7 of 9

Order From : VC-ATG001
A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 613-446-4544

Ship To Contact
Ship To Phone
Ship Via: VENDOR'S TRUCK
Ship Acct:

Buyer Diane Baker
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

14	163349	647.3915 Deflector Rev. C2	8/14/2017	12.00	\$35.00	\$420.00
			Yes			
			8/14/2017			

AS PER MPP-172 SECTION 2.1,
HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2
AS PER MPP-172 SECTION 4.2,
PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N

Line Total: \$420.00

15	162469	647.4112 Clip Rev. N/C	8/14/2017	8.00	\$7.00	\$56.00
			Yes			
			8/14/2017			

AS PER MPP-172 SECTION 2.1,
HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2
AS PER MPP-172 SECTION 4.2,
PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N

Line Total: \$56.00

16	162370	647.4115 Shim Rev. N/C	8/14/2017	10.00	\$6.25	\$62.50
			Yes			
			8/14/2017			

AS PER MPP-172 SECTION 2.1,
HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2
AS PER MPP-172 SECTION 4.2,
PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N

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807-8-9.

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

7/19/2017



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913640

Date: 08-Aug-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
8 ea	Part: 647.4112 Clip Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 21383		Rev: NC PO: PO37017 Line: 15
10 ea	Part: 647.4115 Shim Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 21384		Rev: NC PO: PO37017 Line: 16
7 ea	Part: 646.3210 Support Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 21371		Rev: NC PO: PO37017 Line: 3
12 ea	Part: 646.3711 Clip Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 21374		Rev: A PO: PO37017 Line: 6
6 ea	Part: 647.4110 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 21374		Rev: NC PO: PO37017 Line: 6
Made in Canada.			

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SP17-8-9



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913640

Date: 08-Aug-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	- .9 mils) per drawing. Job: 21376	PO: PO37017	Line: 8
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>08/08/17</u> Certified Signature: <u>[Signature]</u> Receiver Signature: <u>SP17-8-9</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			